

Work Order ID 147738

June 10, 2016 11:01:38 AM

147738

Bell Order
Only

Page 1

U/R

Accept

N9000040100

Item ID: D412-704-015

Revision ID: URF 16-577

Item Name: Co-Pilot's Emergency Cargo Release

Setup Start *NS1*

Stop *NS2*

Start Date: 6/10/2016 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 6/20/2016 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: SLA Date: 6/10/16 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-704	D U/R OK 6/16/16	DAS 6 9-89							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-704-015 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

JUN 23 2016

2 DAS
28
9-89

JUN 30 2016

003

2 DAS
6
9-89

DAS
27
9-89

JUN 23 2016

2 DAS
28
9-89

JUN 30 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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June 10, 2016 11:01:38 AM

Item ID: D412-704-015 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-577 Stop ***NS2***
Item Name: Co-Pilot's Emergency Cargo Release
Start Date: 6/10/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/20/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-704-015 Location: _____ PPP Rev: _____ <i>1x sold</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.03							
Quality Control									

2x

DAS
26 DAS
9-89 27
9-89

JUN 30 2016

16/6/30 *df*

em 16/06/30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Page 1

Work Order ID: 147738

147738

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC IPP
REV:B 12.04.20 per cen-566 DD verf:EC IPP REV:C
12.05.10 per ECN 12-583 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3206-3		Manufactured	No				Each	4.0000		<u>12</u>			
D3206-3									**				
Pedal Arm	DAS 28 9-89												DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA PD.				4					
				Part Duval	146154			4		<u>2</u>			
D412-704-141		Manufactured	No			110	Each	0.0000	1	2			
D412-704-141									**				
Pedal Assembly	DAS 28 9-89									1X B147986			DAS 27 9-89
D412-704-045		Manufactured	No			110	Each	1.0000	1	2			
D412-704-045									**				
Cable Ass'Y	DAS 28 9-89									147412			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST215				1					
				144248				1					
D3207-5		Manufactured	No			110	Each	5.0000	1	2			
D3207-5									**				
Bracket	DAS 28 9-89												DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST024				5					
				116991				5		<u>2</u>			DAS 27 9-89

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Work Order ID: 147738

147738

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

D3207-7 Manufactured No 110 Each 63.0000 1 2

D3207-7

Packer

DAS
28
9-89

**

DAS
27
9-89
DAS
6
9-89

Location Loc Qty Loc Code

ST024 63

110077 4

145451 59

2

D3207-9 Manufactured No 110 Each 4.0000 1 2

D3207-9

Bracket

DAS
28
9-89

**

DAS
27
9-89
DAS
6
9-89

Location Loc Qty Loc Code

ST024 4

122604 4

2

D3208-1 Manufactured No 110 Each 13.0000 1 2

D3208-1

Doubler

DAS
28
9-89

**

DAS
27
9-89
DAS
6
9-89

Location Loc Qty Loc Code

ST025 13

141492 13

2

D3208-11 Manufactured No 110 Each 15.0000 1 2

D3208-11

Filler

DAS
28
9-89

**

DAS
27
9-89
DAS
6
9-89

Location Loc Qty Loc Code

ST026 15

141386 15

2

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Work Order ID: 147738

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Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

D3208-3	Manufactured	No	110	Each	16.0000	1	2	DAS 6 9-89	DAS 27 9-89
D3208-3									
Pedal Mount Angle									
DAS 28 9-89									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST025	16					
			146022	16					
D3208-7	Manufactured	No	110	Each	0.0000	1	2	DAS 6 9-89	DAS 27 9-89
D3208-7									
Filler									
D3208-9	Manufactured	No	110	Each	11.0000	1	2	DAS 6 9-89	DAS 27 9-89
D3208-9									
Doubler									
DAS 28 9-89									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST025	11					
			142241	11					
D3214-1	Manufactured	No	110	Each	13.0000	1	2	DAS 6 9-89	DAS 27 9-89
D3214-1									
Decal									
DAS 28 9-89									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST026	13					
			141572	13					
D4610-1	Manufactured	No	110	Each	7.0000	1	2	DAS 6 9-89	DAS 27 9-89
D4610-1									
Doubler									
DAS 28 9-89									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST112	7					
			119696	7					

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Work Order ID: 147738

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Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

D4610-3	Manufactured	No		110	Each	16.0000	1	2		
D4610-3									DA	DA
Doubler									6	27
									9-89	9-89

DAS
28
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST112	16	
142233	16	

D4610-7	Manufactured	No		110	Each	20.0000	1	2		
D4610-7									DA	DA
Cover									6	27
									9-89	9-89

DAS
28
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST112	20	
142239	20	

MS21919-DG5	Purchased	No		110	Each	20.0000	4	8		
MS21919-DG5									DA	DA
Clamp									6	27
									9-89	9-89

DAS
28
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST293	20	
m134134	20	

D4622-1	Manufactured	No		110	Each	3.0000	1	2		
D4622-1									DA	DA
Placard									6	27
									9-89	9-89

DAS
28
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

st113	3	
132587	3	

D4622-3	Manufactured	No		110	Each	5.0000	1	2		
D4622-3									DA	DA
Placard									6	27
									9-89	9-89

DAS
28
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

st113	5	
132697	5	

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D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 6/10/2016

Required Date: 6/20/2016

Start Qty: 2.00

Required Qty: 2.00

MS35489-149

Purchased

No

110

Each

85.0000

1

2

MS35489-149

GROMMET

DAS

27

DAS

6

9-89

Location

Loc Qty

Loc Code

ST269

85

121692

85

DAS

28

9-89

2

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
X							D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	X						D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (205)
		X					D412-704-015	COPILOT'S EMERGENCY CARGO RELEASE KIT (412)
1	1		X				D412-704-041	PEDAL ASSEMBLY (205/210/212/214)
		1		X			D412-704-141	PEDAL ASSEMBLY (412)
	1				X		D205-704-043	CABLE ASSEMBLY (205)
1		1				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
			1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
			1	1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
			1	1			D3205-3	BACK PLATE (OR ECM 999709-5)
			1	1			D3206-1	PEDAL ARM (OR ECM 999704-1)
		1					D3206-3	PEDAL ARM
	1						D3207-1	BRACKET
	1						D3207-3	BRACKET
1		1					D3207-5	BRACKET
1	1	1					D3207-7	PACKER
		1					D3207-9	BRACKET
1							D3207-11	BRACKET
1	1	1					D3208-1	DOUBLER (OR ECM 999709-1)
1	1	1					D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1						D3208-5	MOUNT ANGLE
1	1	1					D3208-7	FILLER (OR ECM 999709-3)
1		1					D3208-9	DOUBLER
1		1					D3208-11	FILLER
			1	1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1	1					D3214-1	PLACARD (OR ECM 999712-1)
					1		D3217-1	CABLE
						1	D3217-3	CABLE
					1	1	D3257-1	FITTING
					1	1	D3258-1	ANGLE BRACKET
		1					D4610-1	DOUBLER
		1					D4610-3	DOUBLER
			1	1			D4610-5	SHIM
		1					D4610-7	COVER
				1			D4611-1	BUSHING
		1					D4622-1	PLACARD
		1					D4622-3	PLACARD
			1	1	1	1	AN3-10A	BOLT
			1	1			AN315-4R	NUT
					1	1	AN3-5A	BOLT
			2	2			AN3-6A	BOLT
			1	1			AN4-10A	BOLT
			2				AN4-11A	BOLT
				2			AN4-12A	BOLT
			1				AN4-13A	BOLT
				1			MS20002-4	WASHER
				1			MS20004-24	BOLT

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Revision: E

Date: 16.05.05

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
			3	3	2	2	MS21042L3	NUT (OR MS21042-3)
			5	5			MS21042L4	NUT (OR MS21042-4)
4	4	4					MS21919DG5	CLAMP
			1				MS24694-S102	SCREW
				1			MS24694-S104	SCREW
	2						MS35489-10	GROMMET
		1					MS35489-149	GROMMET
			1	1			MS9519-10	BOLT
			4	4	2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
			5	5	2	2	NAS1149D0363J	WASHER (OR AN960JD10)
			3	2			NAS1149D0416J	WASHER (OR AN960JD416L)
			14	13			NAS1149D0463J	WASHER (OR AN960JD416)
					3	3	NAS509-3	NUT

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Only

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U/R

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/10/2016	Start Qty: 2.00	*2*
Required Date: 6/20/2016	Req'd Qty: 2.00	*2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: SLA Date: 6/10/14 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

Change Record

PAGE 1 OF 1

Part Number: D412-704-015

Description: CO-PILOT EMERGENCY CARGO RELEASE (412)

[illegible]